

NCL-19-7524

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie



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RBE332A94-3400-03-7

Job Sheet 199379



Part No: RBE332A94-3400-03-7

Job Qty: 3 pcs

Part Name: Base



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/21/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 11/15/19

Description:

Type: SOLD

Note: DWG RBE332A94-3400-03 Rev A IPP Rev. A 19.02.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	3 pcs	11/15/19	11/15/19	0.17	0.60	Waterjet - Omax		12/19/09/07
110	QC 2	3 pcs	11/15/19	11/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		12/19/09/07
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

8/21/2019

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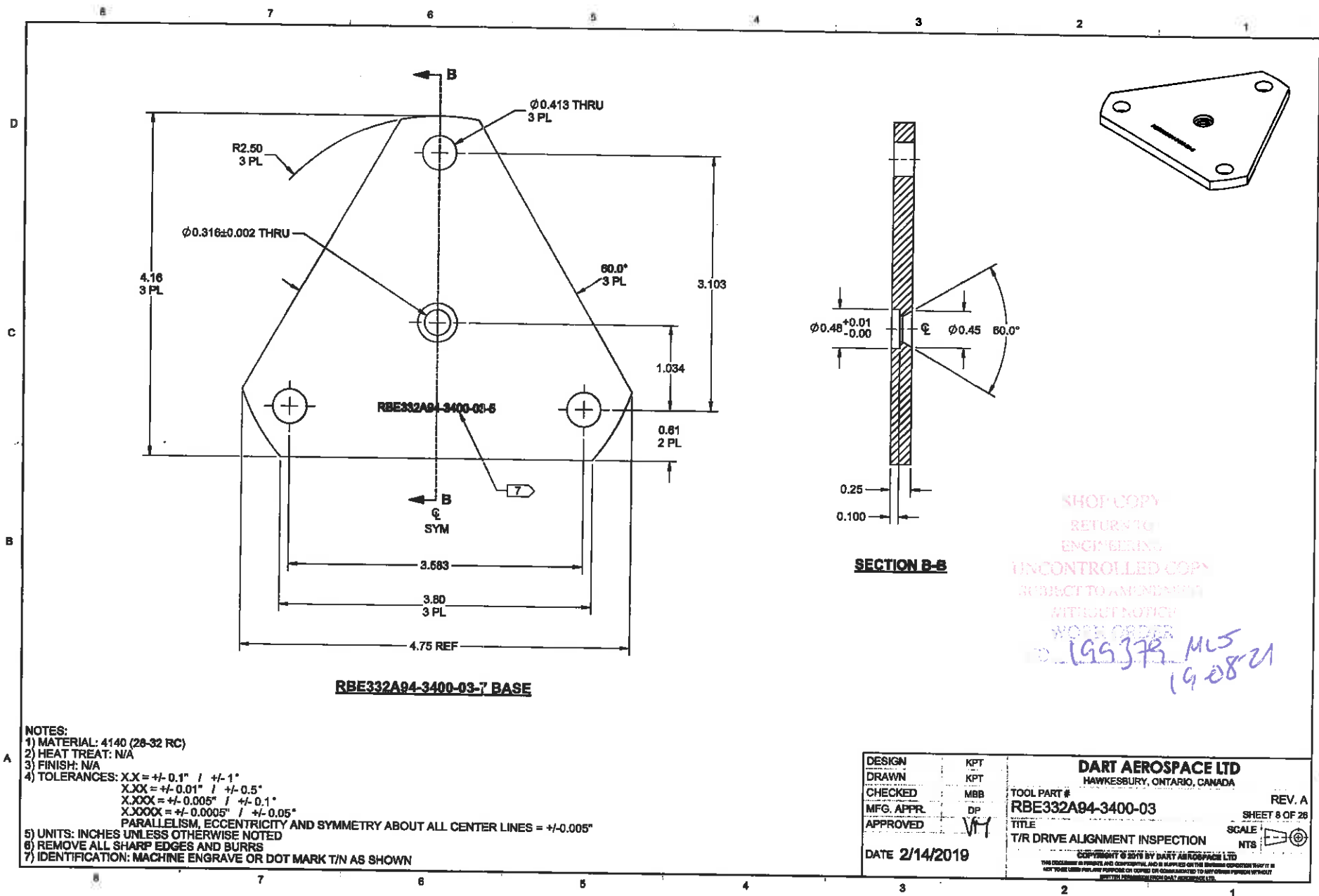
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	NV5000 - 1 - B4B	3 pcs	11/15/19	1.00 3.00	NV5000 - 1 - B4B	
					NV5000 - 2 - B4B	Kf 19-09-17
130	QC 2	3 pcs	11/15/19	0.00 0.00	QC 2 - 1	Kf 19-09-17
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140	QC 8	3 pcs	11/15/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	

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				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150 Packaging 3-1 - Stock - B4B 3 pcs	11/15/19	0.00 0.00		Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	12
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	3 pcs	11/15/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
Part Op 100 - 1-Cut as per DWG. DWG. Rev: <u>A</u> PROG. Rev: <u>A</u> 2-Deburr if necessary Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - 1-Machine as per folio FC700 FOLIO REV: <u>AA</u> DWG REV: <u>A</u> 2-Deburr 130 - QC2- Inspect parts off machine FAI/FAIB 140 - QC8- Inspect parts - second check 150 - Identify as per dwg & Stock Location: <u>V6.001</u> 160 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MT-4140-S-0.250	AISI 4140 / 4142 Steel Sheet 0.250"W	.4500 sf (.15 ea)	100-Waterjet - Omax - 1	5089796	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Omax - 1	MT-4140-S-0.250	0	12	0	

Part Specifications	
Specifications could not be found.	

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SECTION B-B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
195378 ML5
190821

- NOTES:**
 1) MATERIAL: 4140 (28-32 RC)
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: XX = $\pm 0.1"$ / $\pm 1^\circ$
 XJX = $\pm 0.01"$ / $\pm 0.5^\circ$
 XJXX = $\pm 0.005"$ / $\pm 0.1^\circ$
 XJXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) REMOVE ALL SHARP EDGES AND BURRS
 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBE332A94-3400-03	SHEET 8 OF 28
APPROVED	VM	TITLE	SCALE
DATE	2/14/2019	T/R DRIVE ALIGNMENT INSPECTION	NTS
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Container No: S212067



Part: RBE332A94-3400-03-7

Job No: 199379

Serial No/Batch: S212067

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 09/07/19

Entered: JR Date: Oct 24/19



NCR No. 19-7524 **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

Job: <u>199379</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS			
Part No. <u>RBE 332A94-340002-7</u>		Skid-tube Machining ☒ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier Quality ☐

Date: <u>19-09-18</u>	Sequence #: <u>120</u>	QTY Affected: <u>16</u>	MRB (QSI042) DAS 51 9-89 <u>19/09/18</u>
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Description Work Order Deviation	Disposition	Completed By
Part at Section B is -0.020 under the Drawing dimension of 0.250	this part is not critical, and is Acceptable to have -0.020 in this area (0.250) Section B	<u>Kt</u> 19-09-18
		Lead hand / Supervisor <u>amk</u> 19/09/20
		QC / QA Coordinator DAS 68 9-89 SEP 23 2019

Root Cause	FAULT CATEGORY			
Operator ☒	☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong
Manufacturing Process ☐	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☒ Outside Tolerance
Equip/Tooling ☐	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing
Handling/Preservation ☐	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish
Material ☐	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing
Product Improvement ☐	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread
Process Improvement ☐	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
Human Factors ☐	Other/Details:			